

Work Order ID 59239

Friday, May 28, 2010 9:50:23 AM



Page 1

Item ID: D4091-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 5/27/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 10-5-28 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4091

A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.450" LONG

aml 10/06/0512 Ø

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA920 AND DWG

FOLIO REV: ADWG REV: AH.A 10/06/0612 Ø

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

B.A 10/06/06

12

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

MMZ 10/06/06

12

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

= 7 m-l 10/06/07

(12X)

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Work Order ID 59239



Page 4

Work Order ID 59239



Friday, May 28, 2010 9:50:23 AM

Page 3

Item ID:	D4091-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Mounting Lug				Stop	
Start Date:	5/27/2010	Start Qty: 12.00				
Required Date:	6/4/2010	Req'd Qty: 12.00				
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo start: 8:00am Temp: 320°C F.W 8:30am	0.00 0.00		10/06/08		12	0		
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							BR 10-6-8.
170 Packaging Packaging	Identify as per dwg & Stock Location: ST 460 Memo	0.00 0.00							MF 10-6-9.

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Friday, May 28, 2010 9:50:28 AM

Page 1

Work Order ID: 59239



Parent Item: D4091-1



Parent Item Name: Mounting Lug

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	470.5321	0.1251	1.580211			



Lug Extrusion

Location

Loc Qty

Loc Code

MAT06

470.5320795

43722

180

→ 45800

290.532079

1.5803 on 10/06/05

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DART AEROSPACE LTD		Work Order: 59239
Description: MOUNTING LOG		Part Number: D4091-1
Inspection Dwg: D4091 Rev: A		Page 1 of 1

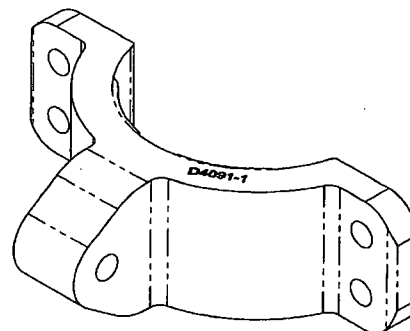
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.45	+/- .030	4.452	✓			
1.38	+/- .030	1.378	✓			
R0.03-R0.070	R0.03 / R0.070	0.063	✓			
0.270	+/- .030	0.271	✓			
0.293	+/- .010	0.293	✓			
R1.20	+/- .030	R1.20	✓			
3.700	+/- .010	3.700	✓			
0.375	+/- .010	0.377	✓			
0.625	+/- .010	0.625	✓			
0.375	+/- .010	0.377	✓			
Ø0.257	+0.006/-0.001	Ø0.258	✓			
R0.34	+/- .030	R0.34	✓			
2.310	+/- .010	2.309	✓			
1.91	+/- .030	1.908	✓			
0.69	+/- .030	0.685	✓			
R0.40	+/- .030	R0.400	✓			
Ø0.257	+0.006/-0.001	Ø0.259	✓			
35°	+/- 1/2 °	35°	✓			
R0.63	+/- .010	R0.63	✓			

Measured by: KA	Audited by: MM	Prototype Approval:	N/A
Date: 10/06/06	Date: 10/06/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	







D4091-1 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59239
R/10-5-28

RELEASED
2010-04-28
W

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: 0.31 lbs

A		NEW ISSUE		CP	10.03.29
REV.	DESCRIPTION			BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	CP				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4091	SHEET 1 OF 2		
APPROVED		TITLE	SCALE		
DE APPR.		MOUNTING LUG	NTS		
DATE	10.03.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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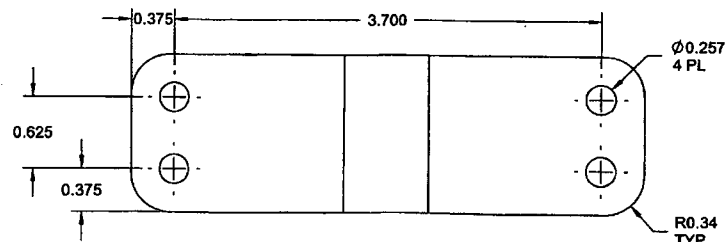
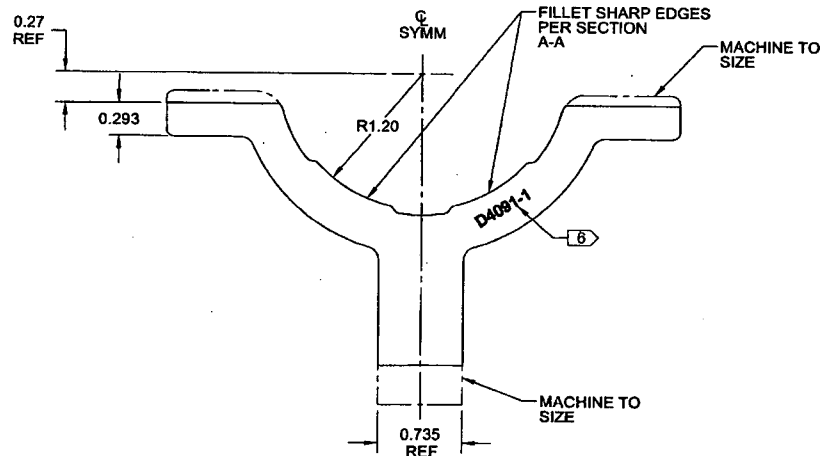
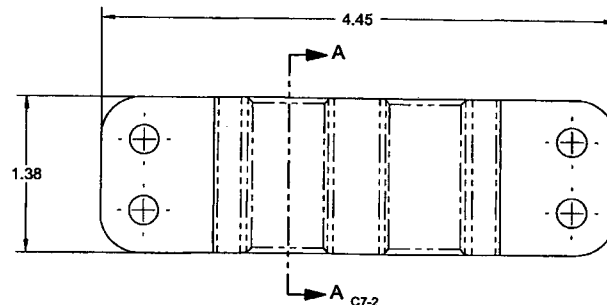
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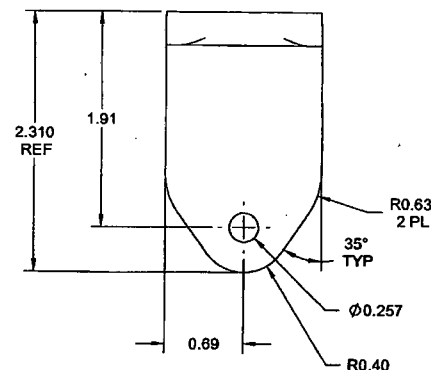


R0.03-R0.07
TYP AROUND PAD

SECTION A-A C5-2



D4091-1 MOUNTING LUG



RELEASED
2010-04-20
MD

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4091	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	10.03.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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